

303 Hex Bar 500

Work Order ID 144629

144629

Page 1

April 21, 2016 2:26:36 PM

Item ID: D3622-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Ball Stud

Start Date: 5/3/2016

Start Qty: 40.00

40

Cust Item ID:

Required Date: 5/17/2016

Req'd Qty: 40.00

40

Customer:

Reference:

Approvals:

Process Plan: MLSDate: APR 22 2016 Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3622

D

100

0.49

100

Hardinge

Hardinge CNC LATHE SMALL

Memo

4.80

Hardinge CNC Lathe Small

1-TURN AS PER FOLIO FA686 & DWG D3622,
FOLIO REV: AA
DWG REV: D
2-DEBURR AS REQUIRED

DAS

49
9-89

DAS

49
9-89

16/06/10

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.40

Quality Control

DAS

49
9-89

DAS

49
9-89

16/06/10

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.80

Quality Control

42

Ø

DAS

45
9-89

2010613

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
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								Lead hand / Supervisor Approval Verification																	
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Root Cause		FAULT CATEGORY																							
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OTHER : _____																									

Work Order ID 144629

April 21, 2016 2:26:36 PM

144629

Page 2

Item ID: D3622-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Ball Stud
 Start Date: 5/3/2016 Start Qty: 40.00 ***40*** Cust Item ID:
 Required Date: 5/17/2016 Req'd Qty: 40.00 ***40*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <i>5046</i>	0.00							
130									
Packaging	Memo	0.40							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	4.00							
Quality Control									

JUN 15 2016

DMS
6
980

16/6/15 *[Signature]*

MC5 JUN 15 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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				OTHER : ☐																																																																					

Picklist Print

April 21, 2016 2:26:36 PM

Page 1

Work Order ID: 144629

144629

Parent Item: D3622-1

D3622-1

Parent Item Name: Ball Stud

Start Date: 5/3/2016

Required Date: 5/17/2016

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP Rev:A New Issue 07-04-24 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303H0.500		Purchased		No		100	f	16.0800	0.108	4.547368			

M303H0 500

303 HEX BAR .500

Location

Loc Qty

Loc Code

MAT018

16.08

m132058

4.08

m134495

12

4.87

DAS
49
9-89

16/06/10

DQA: _____ Date: _____

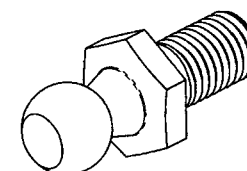


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐		Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
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Equip/Tooling ☐		Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
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Tribal Knowledge ☐		Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐			
LOA ☐		Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐			
Substation ☐		Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐		Manufacturing Process ☐	OTHER : ☐						
Misidentified ☐		Past Due ☐							



4629 MJS
160422 **D38**

D3622-11 BALL STUD
SHOWN

APPROVED

D	ADDED -15. ADDED COLUMN D, E AND F. RENAMED SUBSEQUENT COLUMNS.	AK	16.03.15
C	SHEET 1: ADD -5, -7, -9, -11 & -13. ADD D3622-X TABLE. SHEET 2 DELETED	JPH	10.07.20
B	ADD -3 (SHEET 2)	HS	08.09.18
A	NEW ISSUE	MB	07.04.13
REV.	DESCRIPTION	BY	DATE

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AK		
CHECKED	VS	DRAWING NO.	REV. L
MFG. APPR.	JL	D3622	SHEET 1 OF
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	BALL STUD	NT

DATE	16.03.15
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